

AMENDMENTS TO THE CLAIMS

1. (Currently amended) The method of making conical connectors that are open at both ends for use in HVAC ducting, comprising:

placing a conically shaped workpiece that is open at both ends and is of [[thin]] 22-26 gauge metallic material into engagement with a spin die, the spin die having at least one generally cylindrically shaped surface portion;

spinning the conically shaped workpiece that is open at both ends about its longitudinal central axis; and

forming the conically shaped workpiece that is open at both ends as the workpiece is spinning to conform either one or both longitudinal ends of the workpiece to the shape of the spin die generally cylindrically shaped surface portion.

2. (Currently amended) The method according to Claim 1, wherein the spin die has two generally cylindrically shaped concentric surfaces and the workpiece that is open at both ends is formed during spinning of the workpiece to conform either one or both longitudinal ends of the workpiece to the shape of both generally cylindrically shaped concentric surfaces.

3. (Original) The method according to Claim 2, wherein the generally cylindrically shaped surfaces have different diameters.

4. (Original) The method according to Claim 2, wherein the spin die is positioned within the workpiece.

5. (Original) The method according to Claim 2, wherein the workpiece is positioned within the spin die.

6. (Original) The method according to Claim 2, wherein the workpiece is formed against the concentric surfaces of the spin die.

7. (Original) The method according to Claim 1, wherein the spin die is positioned within the workpiece.

8. (Original) The method according to Claim 1, wherein the workpiece is positioned within the spin die.

9. (Original) The method according to Claim 1, wherein the workpiece is formed against the generally cylindrically shaped surface of the spin die.

10. (Currently amended) The method according to Claim 1, further comprising forming a mating flange at ~~at least~~ either one or both of the longitudinal end portion portions of the workpiece by spinning the workpiece, and as the workpiece is spinning, expanding the ~~at least~~ either one or both of the end portion portions of the workpiece to form a generally annularly shaped mating flange portion extending generally transversely to the longitudinal central axis of the remainder of the workpiece.

11. (Currently amended) The method according to Claim 10, further comprising creating a hem section from the outer perimeter portion of the mating flange while the workpiece is spinning by forming the outer perimeter portion of the mating flange to extend away from the surface of the mating flange to overlie the corresponding end of the workpiece and to be disposed substantially concentrically to the longitudinal central axis of the workpiece.

12. (Currently amended) The method according to Claim 11, further comprising forming a return flange at either one or both longitudinal end portions of the workpiece by turning a portion of the hem section located distally from the mating flange over on itself.